

Work Order ID 148158

Monday, June 27, 2016 11:38:45 AM

148158

Page 1

Item ID: D4366-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Run-on Landing Wearplate Fwd
 Start Date: 6/21/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: **DAS 13** Date: **JUN 27 2016** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4366	C								

110 0.00 ***110*** 2 EL 16-8-10

Large Fab Memo 0.42
 Large Fab ***FRONT BENT (1.37) COULD BE OVER BENT HIGHER BY 0.25"-0.50" ***
 1- Weld D4367-041 to wearplate by positioning holes together as per dwg D4366
 304 S.S. Welding Rod
 BATCH #: **17123823**
 2- Transfer drill holes in bar and cut extra material on bar if necessary

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 ***120*** 2 AUG 10 2016 **DAS 24 9-89**
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY								
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ AS Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐			Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____								

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Page 2

Item ID: D4366-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Fwd

Start Date: 6/21/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ***FRONT BENT (1.37) COULD BE OVER BENT HIGHER BY 0.25"- 0.50" ***	0.00 0.01				<u>2</u>			DAS 38 AUG 1 0 2016
140 *140* Small Fab Small Fab	Small Fab Memo 1- After finish, coat entire top (concave) surface as per note 9 dwg D4366. TEXTURED COATING B#: <u>135064</u>	0.00 0.01				<u>2</u>			DAS 41 9-89 16-8-10
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>2</u>			DAS 38 9-89 AUG 1 1 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
11.11.11				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Run-on Landing Wearplate Fwd

Start Date: 6/21/2016 Start Qty: 2.00

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Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FP-007</u>	0.00							
160									
Packaging	Memo	0.00				<u>X2</u>	<u>d</u>	<u>91</u>	<u>1608/15</u>
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.03							
Quality Control									

DAS
21
9-89

AUG 15 2016

DAS
21
9-89

AUG 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
1001 001				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Picklist Print

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148158

Parent Item: D4366-041

D4366-041

Parent Item Name: Run-on Landing Wearplate Fwd

Start Date: 6/21/2016

Required Date: 6/27/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.04.12 new issue DD verf:EC IPP REV:B
 14.02.06 DWG PB1 DD VERF:JLM IPP REV:C 14.04.22
 DWG B DD VERF:JLM IPP REV:D 14.05.28 DWG PC1
 DD VERF:JLM IPP REV:E 16.06.17 DWG.C DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4366-1		Manufactured	No				Each	4.0000		2			
D4366-1									**				
Plate													

Location	Loc Qty	Loc Code
WA001	4	
<u>128063</u>	4	

D4367-041		Manufactured	No				Each	0.0000		2			
D4367-041									**				
Bar Weldment													

148218x2

DQA: _____ Date: _____



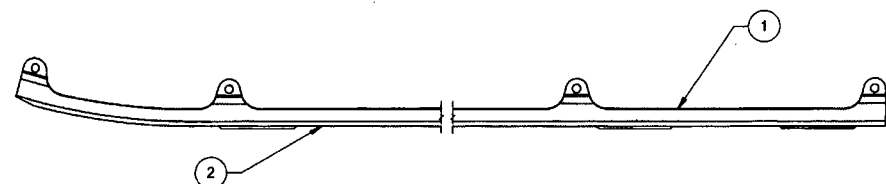
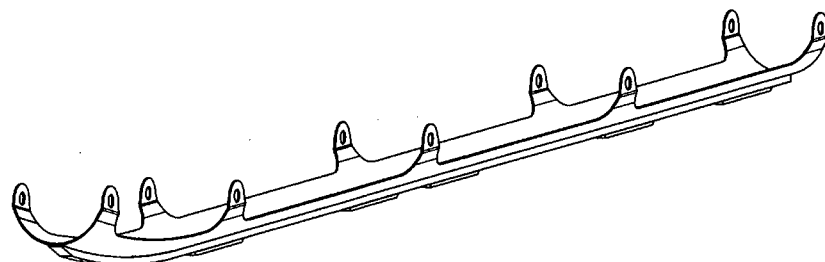
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4366-041	WEARPLATE ASSY
1	1	D4366-1	PLATE
2	1	D4367-041	BAR



D4366-041 FWD WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-041" PER QSI 044 6.1
- 7) WEIGHT: D4366-041 = 5.30 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4367-041 BAR WELDMENT FROM D4366-1 WEARPLATE AFTER WELDING



RELEASED
2016-06-16
EAL-574

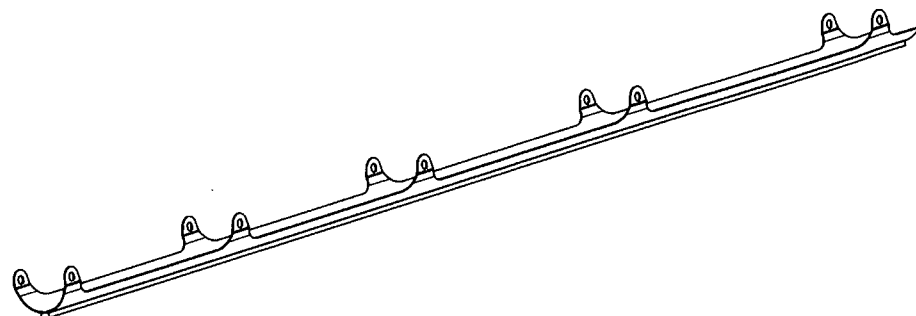
APPROVED

JUN 27 2016
DAS
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9-59

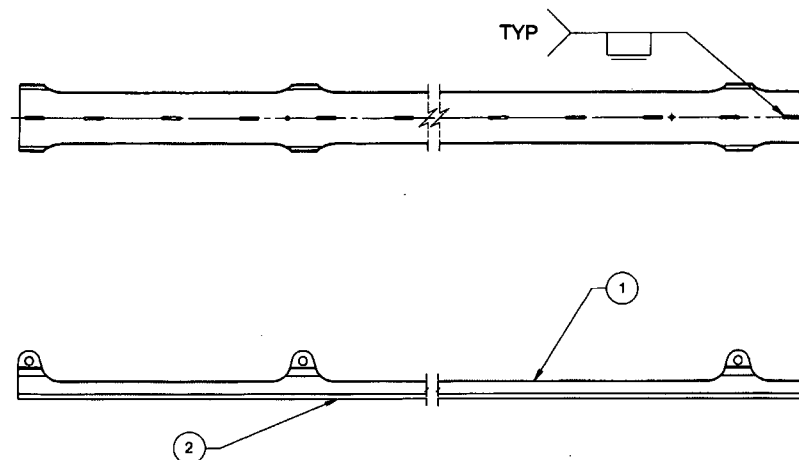
W10148158

C	D4367-041 WAS D4367-1, D4367-043 WAS D4367-3, REMOVE HARDCOAT WELD (MOVED TO D4367), UPDATE TOLERANCES, PART WEIGHTS (SH 3&4), RELABELED VIEWS, UPDATE NOTES	DB	16.04.11
B	TEXTURED COATING WAS ROCKGUARD 4714 (BOM TABLE), REVISE NOTE 10 (SH 2).	DB	13.11.04
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 1 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4366-043	WEARPLATE ASSY
1	1	D4366-3	PLATE
2	1	D4367-043	BAR WELDMENT



D4366-043 AFT WEARPLATE ASSY



NOTES:

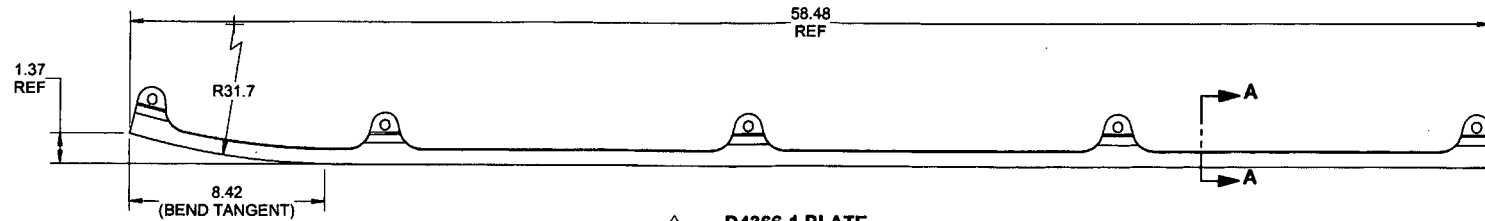
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4366-043" PER QSI 044 6.1
- 7) WEIGHT: D4366-043 = 6.56 lbs
- 8) WELDING: PER QSI 004
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES THRU D4367-043 BAR WELDMENT FROM D4366-3 WEARPLATE AFTER WELDING

RELEASED
2016-06-16

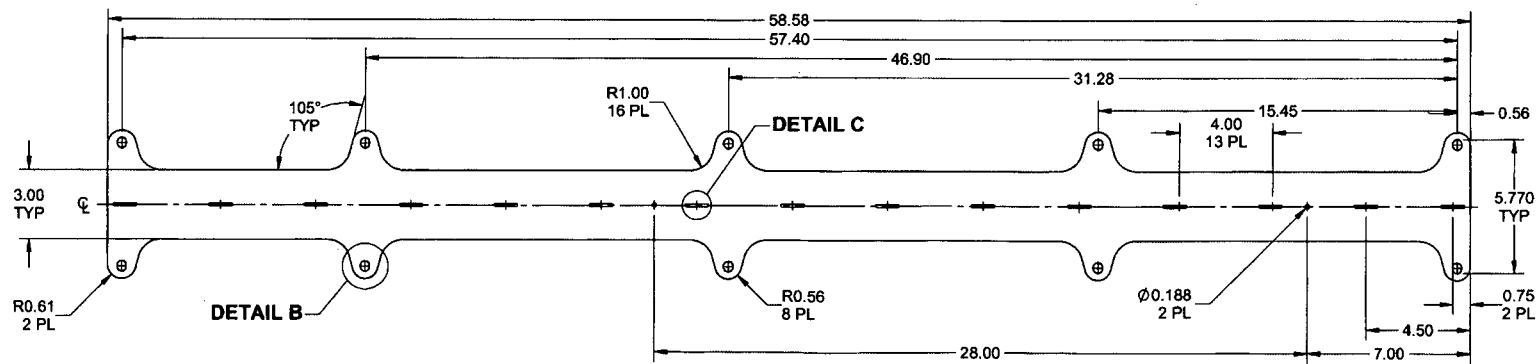
APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	DB	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 2 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	16.04.11	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS SERVICE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D4366-1 PLATE
(MAKE FROM D4366-1F)



D4366-1F PLATE
(FLAT PATTERN)

NOTES:

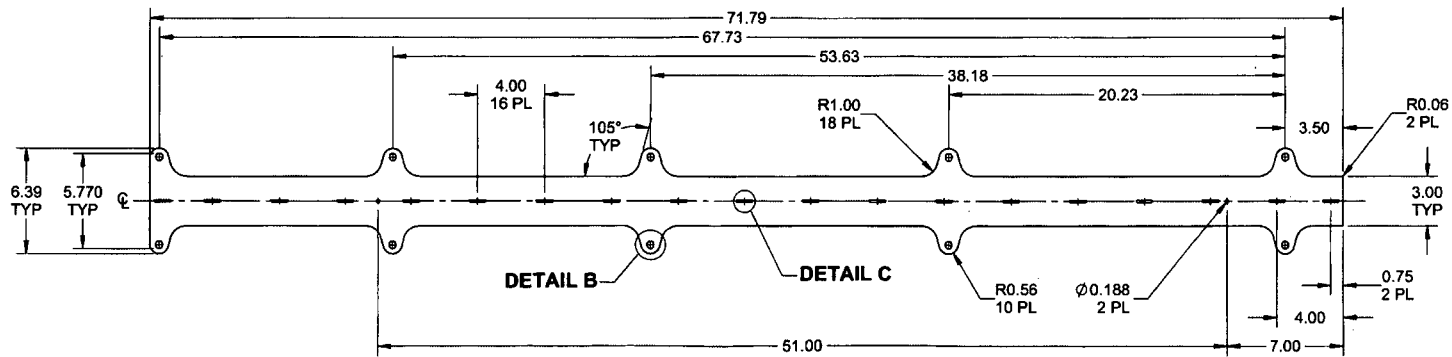
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 18 GAUGE (0.050 THICK), REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.79 lbs

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DESIGN		SC		DART AEROSPACE USA, INC.	
DRAWN		DB		EUGENE, OR	
CHECKED		ML		DRAWING NO.	REV. C
MFG. APPR.		DD		D4366	SHEET 3 OF 5
APPROVED		WM		TITLE	SCALE
DE APPR.		DS		WEARPLATE ASSY	NTS
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D4366-3 PLATE
(MAKE FROM D4366-3F)



D4366-3F PLATE
(FLAT PATTERN)

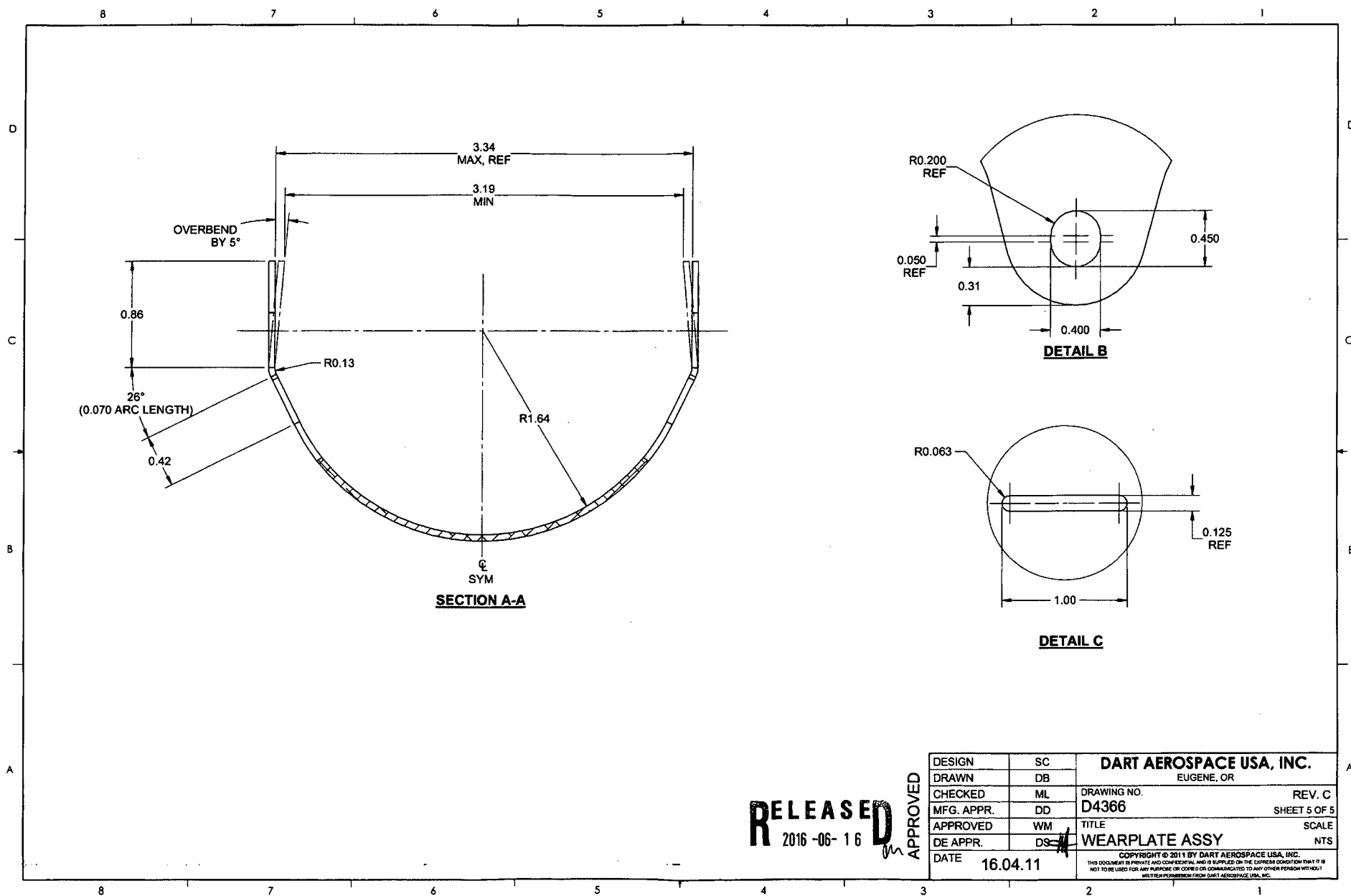
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240, 18 GAUGE (0.050 THICK),
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.36 lbs

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MFG. APPR.	DD	D4366	SHEET 4 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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DESIGN	SC	DART AEROSPACE USA, INC.	
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CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4366	SHEET 5 OF 5
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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